

Date: Thursday, 16/04/2009 1:43:10 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PLUG		
Job Number	: 47251			Part Number	: D25941		
Estimate Number	: 10178			Drawing Number	: D2594 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/04/2009	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 23/04/2009	Qty:	500
Previous Run	: 46435			Um:	Each		
Written By	:						
Checked & Approved By	: JUD 09.04.16						
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) M110250X 13.75" 29.069 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch M109733X 280 parts = 15.316 <i>RF 09.04.18</i>		
2.0	HARDINGE DOOSAN.	HARDINGE CNC LATHE SMALL <i>This Batch only 09/04/16</i>
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. <i>RF 09/04/17</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>RF 09/04/17</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>RF 09/04/18</i> <i>SOO</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 <i>09-04-21</i> <i>X500</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING		<i>M 110939</i>
Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)		
START TIME:	<i>10:35</i>	
OVEN TEMPERATURE:	<i>320°</i>	<i>502</i>
FINISH TIME:	<i>11:05</i>	<i>BL 09-04-22</i>
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>09-04-22</i>
8.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		<i>502</i>
Identify and Stock		
Location: <i>FP-A</i>		<i>BL 09-04-23</i>
9.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		<i>09/04/24</i>
Job Completion		
		<i>11 09-04-24</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47251
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

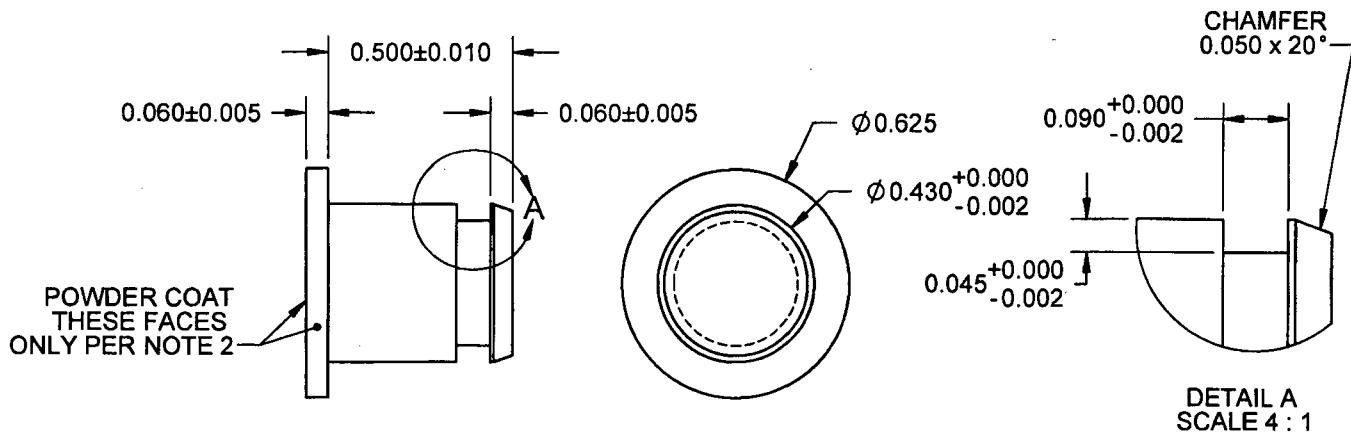
Measured by:	<i>Ank</i>	Audited by:	<i>SP</i>	Prototype Approval:	N/A
Date:	09/04/17	Date:	09/04/18	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	08.07.23	Diameter symbol added	KJ/DD	DA

DART

DESIGN <i>AB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>AB</i>	DRAWING NO. D2594
DATE 06.11.20		REV. C SHEET 1 OF 1 SCALE 2:1

RELEASER

06.11.28 *AB***D2594-1 PLUG****D2594-1 PLUG NOTES:**

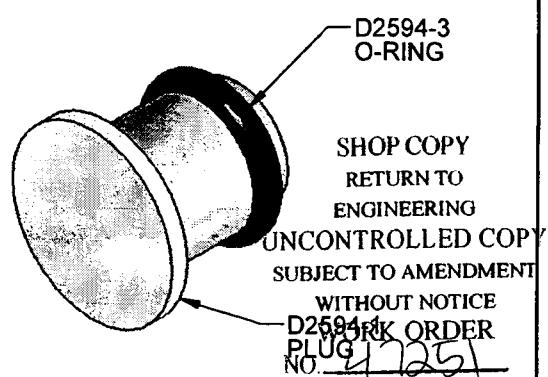
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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